

Work Order ID 113530

February-20-14 7:40:13 AM

113530

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Item ID: D412-711-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Vertical Reference Window
 Start Date: 2/20/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/27/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLC Date: 14-02-20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711-101	B								
100		0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefiles and create labels for PPP D412-711-101 Change 002								
110		0.00							
110	HAND FINISHING THERMOFORMING								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Set up Machine as per folio FTA 077 and D711W program using mould DT9640								
120		0.00							
120	HAND FINISHING THERMOFORMING								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Cut Blanks to 37.5" by 43"								

SP

DAS
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9-89

MAR 10 2013
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MLC 140310

x2

Dh
14/03/20

x2

Dh
14/03/20

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	THERMOFORMING MACHINE					x2			OK
Thermoform	Memo	0.00							14/02/20
Thermoforming Machine	Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077								
	Dwg. Rev. <u>B</u>								
	Folio Rev. <u>A.</u>								
	Visually inspect for proper formation and clarity								
	Visually and inspect magic eye								
	Verified by: <u>OK</u>								
160		0.00							
160	HAND FINISHING THERMOFORMING					X1			B 14/03/03
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1) Trim off excess flange material 2) Buff out any light scratches or 3) Etch part number and batch number					Y1			SCRAP PTO.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Sh Date: 14/03/17QA Closed: Sh Date: 14-3-17

Work Order: <u>113530</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D412-711-101</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>14-3631</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Thermoforming ☒	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒				WINDING BAD	DAS 16 9-89	\$ 4.52	Sh		DAS 16 9-89
Equip/Tooling ☐				AD. Error					
Operator ☐				Acrylic Poorly FORMED	Q2042 13/03/13	SCRAP + Destroy	14/03/17	DAS 16 9-89	14/03/12
Material ☐				AT FLANGE		Wc Replne			
Setup ☐				SPACIAL OF CLAMPS		update Poilo / work instructi to ADA	Sh 14/03/17		Q2042
Other ☐				RE Wb Poilo not clear		correct clampi spec			
Process ☐	14/02/20	130	1						
Supplier ☐									
Training ☐									
Unapproved ☐									

about clamp space

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☒ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions	☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D412-711-101

Accept

N900040100

Setup

Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 2/20/14 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 2/27/14 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC2- Inspect parts off machine FAI/FAIB	0.00				1			<i>EB 14/03/03</i>
170									
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								
180	QC5- Inspect part completeness to step on W/O	0.00				1			
180									
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								
185	QC4- 100% Inspect kits for completeness	0.00							
185									
QC	Memo	0.00							
Quality Control									

*02-0
28
SVD*

14/3/10

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS
190	Identify as per dwg & Stock Location: <u>090</u>	0.00								
190										
Packaging	Memo	0.00								
Packaging										
200	QC21- Final Inspection - Work Order Release	0.00								
200										
QC	Memo	0.00								
Quality Control										

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MCS 14-03-17

4-03-10

Picklist Print

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Work Order ID: 113530

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Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 2/20/14

Required Date: 2/27/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.236

Purchased

No

sf

360.0000

43

MACRI ICS 236

Plexiglass G .236"

**

43

14/03/03

Location

Loc Qty

Loc Code

therm

360

M127669

160

M127867

200

DART AEROSPACE LTD		Work Order: 113530
Description: Replacement Window		Part Number: D412-711-101
Inspection Dwg: D412-711-101	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 14/03/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
N/A 2.00	+/-0.030	2.14	✓		DL-02	
1.98	+/-0.030				+	
1.50	Min	1.59	✓		DL-02	
0.090	Min	.096	✓		HLRA	
0.070	Min	.091	✓		HLRA	
0.050	Min	.068	✓		HLRA	
15.0	+/-0.5					

Measured by: JB

Date: 14/03/03

Audited by: Sh

Date: 14/03/03

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	
C	13.06.03	Dimensions updated per Dwg Rev B	KJ <u>Sh</u>	<u>JA</u>

